Mori Seiki CNC Lathe Large

2- File transition lines smooth. 3-Remove sand and plugs

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Work Order ID 60461 Monday, July 12, 2010 8:31:18 AM Accept D212-664-207TRN Item ID: **Revision ID:** Item Name: Crosstube Turning Detail **Cust Item ID:** Start Date: 7/12/2010 Start Qty: 1.00 **Req'd Qty:** 1.00 **Customer:** Required Date: 7/15/2010 Reference: **Tooling:** Date: Date: Process Plan: Approvals: SPC (Y/N): Date: Date: ____ Tool # Plan Tool ID Set Up/ Operation Sequence ID/ Code Run Hours Work Center ID Description 0.00 OC1- Inspect dimensions to dimension sheet 0.00 QC Memo Quality Control 0.00 QC8- Inspect parts - second check 140 2 iolostis QC Memo Quality Control 0.00 Crosstubes Chemical Conversion 150

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Hand Finishing Crosstubes

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Quality Control

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Work Order ID: 60461 Parent Item: D212-664-207TRN Parent Item Name: Crosstube Turning Detail Comments: IPP Rev:A New Issue 08-03-06 DD verified by:ec IPP Rev B 08.04.02 Removed polish EC verified DD Component Item ID/ Replacement Mfg/ Item Location Location Seq ID Measure Hand Qty Issued Issued D6008-132 Manufactured No 110 Each 5.0000 1 1 Location Loc Oty Loc Code	•					,			16		د	
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DART AEROSPACE LTD	Work Order:	40461
Description: Crosstube Assembly (205/212 Low Aft)	Part Number:	D212-664-247
Inspection Dwg: D212-664-247 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	х	First Article	Prototype
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	spection Sheet wing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	0.438	+/-0.010	0-438	/		vers	
	2.680	+0.005/-0.000	2.685	1		ų	
	2.680	+0.005/-0.000	2.685			ч	
	2.687	+0.005/-0.000	2.692	_		ч	
	2.802	+0.005/-0.000	2.807			u	
_	2.906	+0.005/-0.000	2.911	/		ч	
EA	3.009	+0.005/-0.000	3.014	/		u	
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0,	3.250	+0.005/-0.000	3.250			4	
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	2.680	+0.005/-0.000	2.685			-11	
	2.687	+0.005/-0.000	2.692	/		4	
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E B	3.009	+0.005/-0.000	3-014	/		ч	<u> </u>
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	128.268	+/-0.030	128.270		•	TAP Mere	4

Measured by:	0.1		Audited by:	Prototype Approval:	N/A
Date:	10.09	. 14	Date: 10/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.07	New Issue (P/O D212-664-207)	KJ/EC IA	
В	10.04.01	Dwg Rev updated	KJ QQ	
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Item	Qty -247	Qty -247B	Part Number	Description
1	X		D212-664-247	CROSSTUBE ASSEMBLY (205/212 LOW AFT)
2		Х	D212-664-247B	CROSSTUBE ASSEMBLY (214 LOW AFT)
3	1		D6008-132	CROSSTUBE
4	2	2	D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6	2	2	D3660-1	CUFF
				
	4	4	MS21920-28	CLAMP (OR MS21920-30)
8	44	44	CR3212-4-06	RIVET (OR M7885/3-4-06)
9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
10	A/R	A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

1) MATERIAL: MANUFACTURED FROM D6008-132

FINISHED LENGTH = 128.268±0.020 (BEFORE BENDING/TRIMMING)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2

PAINT OUTSIDE PER DART QSI 005 4.2
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

UNITS: INCHES UNLESS OTHERWISE NOTED. BREAK SHARP EDGES: 0.005 TO 0.010 MAX.

IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.

USING VIBRATING STYLUS."

7) WEIGHT: D212-664-247 B = 36.6 lbs (PER IIN-D212-664)
D212-664-247 B = 36.6 lbs (PER IIN-D212-664)

8) PART IS SYMMETRIC ABOUT CENTERLINE.

9) WHEN MACHINING TAPER; RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD
BE SMOOTH.

19 BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6%
BASED ON 0.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.

11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

12) INSTALL D2940-1 SUPPORTUSING 0.03 TO 0.05 THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF
D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER
INSTALLATION AND PRIOR TO PACKAGING.

D290-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QST015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

13) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.

14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.

DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE

UNACCEPTABLE.

15 TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

16 INSTALL D3860-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 82 SEALANT BETWEEN CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.

17) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

SHOP COPY **RETURN TO** ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT

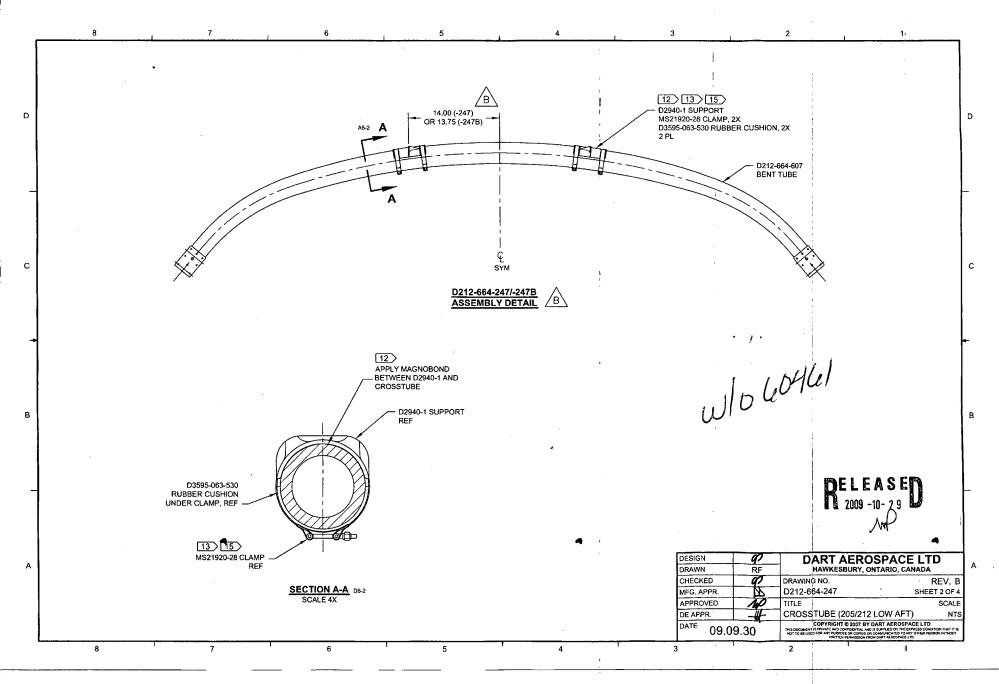
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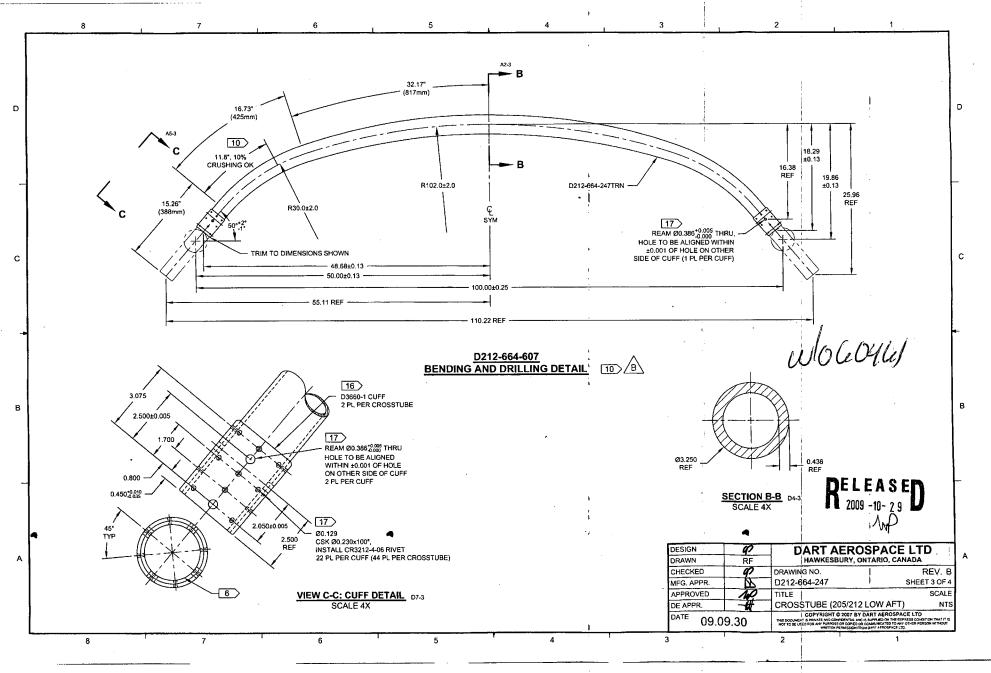
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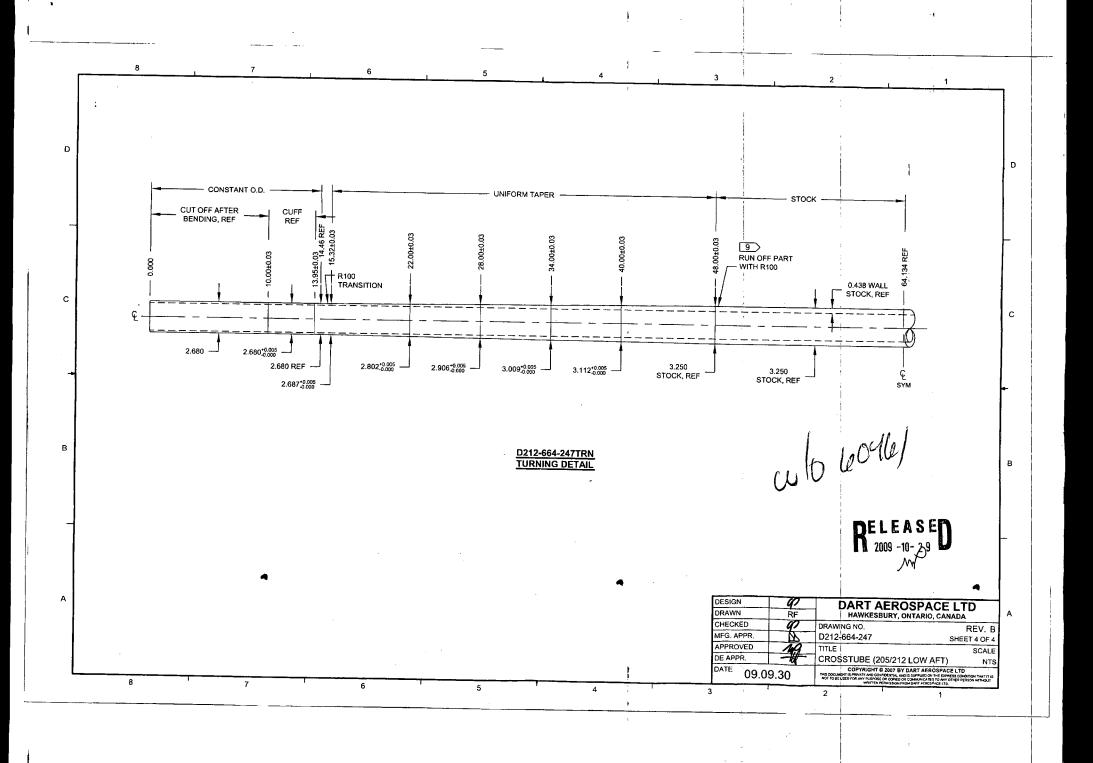


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